FIG. 1

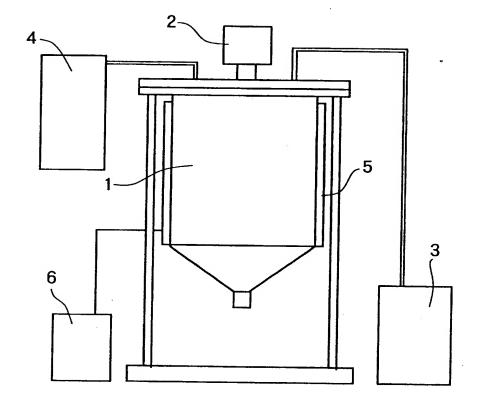


FIG. 2

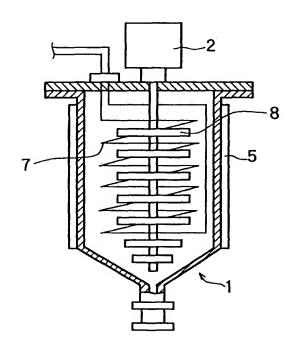
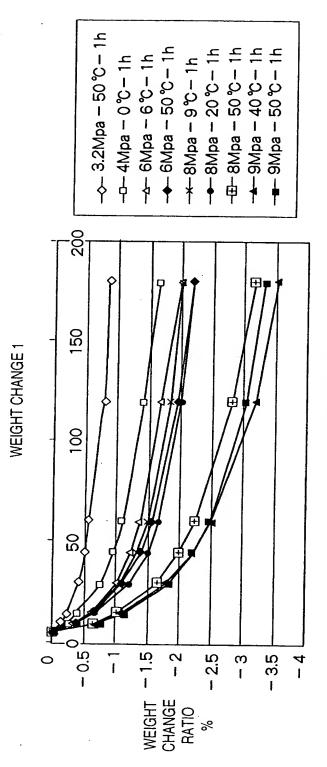


FIG. 3



ELAPSED TIME MIN

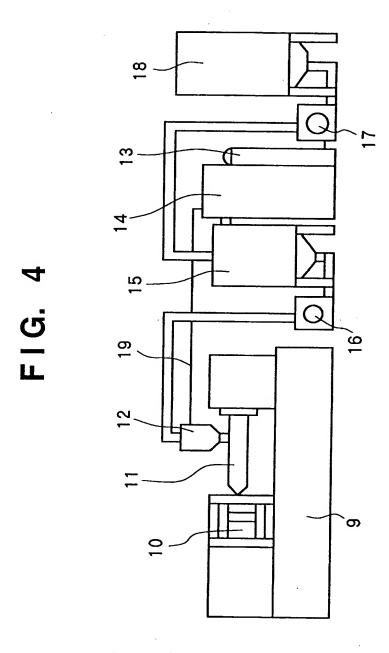


FIG. 5

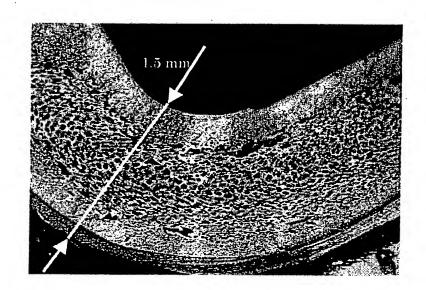
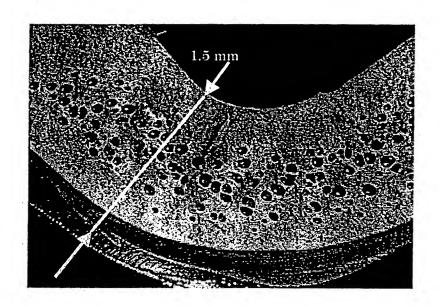


FIG. 6



F1G. 7

·	HIPS (A)	HIPS (A) HIPS (B)	HIPS (A)	HIPS (A)	HIPS (C)	HIPS (A)	HIPS (A)
. FOAMING AGENT	CO ₂	CO2	202	CO ₂	CO ₂	CO2	CO2
SATURATION PRESSURE Mpa	9	9	ω	ω	ω	ω	6
SATURATION TEMPERATURE °C	90	50	20	50	50	50	40
SATURATION TIME h	•	~	1	-	-	2	-
STORAGE PRESSURE Mpa	1	1	1.2	9.	1.6	2	2.5
STORAGE TEMPERATURE °C	10	10	6-	ည	တ	7	4
STORAGE TIME h	. 0.5	-	-	-	2	-	-
WEIGHT CHANGE %	× 1%	< 1%	< 1%	< 1%	<1%	< 1%	< 1%

F.G. 8

	HIPS (A)	HIPS (A) PC / ABS	PC / ABS	PPE	PPE+GF PPE+PS	PPE + PS	ည
FOAMING AGENT	CO ₂	N2	CO ₂	CO ₂	CO2	CO2	N ₂
PERMEATION PRESSURE Mpa	80	80	∞ :	&	8	8	6
PERMEATION TEMPERATURE °C	50	50	20	20	50	20	50
PERMEATION TIME h	-	1	-		-	-	1
STORAGE PRESSURE Mpa	1.5	2.4	1.2	1.8	. 2	1.8	2
STORAGE TEMPERATURE °C	5	3	ဇှ	7	15	က	10
STORAGE TIME h	.	1	-	+	2	-	-
WEIGHT CHANGE %	< 1%	< 1%	< 1%	< 1%	< 1%	< 1%	< 1%